

Shp Oct. 25

Work Order ID 62585-1



Monday, October 04, 2010 3:20:41 PM

Item ID: D206-628-021BL

Accept



Setup Start



Revision ID:

Split

Stop



Item Name: Heli-Access-Step LH, Blue

Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: umf

Date: 10-10-04

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-628	F								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy blue file and type labels as per PPP D206-628-021 CHG 002								
110		0.00							
	Pick Kit								
Packaging	Memo	0.00							
Packaging									
120		0.00							
	QC4- 100% Inspect kits for completeness								
QC	Memo	0.00							
Quality Control									


8/10/10/25
CHG 003 PER ECN 1118

Ph →
JG for BG 10-10-11

10/10/10/25 (40)

8/10/10/25

72
4H

W/O: 62585		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		Perm. change						
10/10/25	# 100	update CHG # to correct change		10/10/25			S 10/10/25	

Part No: D206-628-021 BL PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62585

Monday, October 04, 2010 3:20:41 PM



Page 2

Item ID: D206-628-021BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH, Blue

Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D206-628-021

Location: 14
PPP Rev: 5

10/10/28
MF

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/28
MF
10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 3:20:40 PM

Page 1

Work Order ID: 62585



Parent Item: D206-628-021BL



Parent Item Name: Heli-Access-Step LH, Blue

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevF: add AN960JD416 DD 09.11.17 verified by:cc

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A Bolt		Purchased	No				Each	168.0000	4	16			
---------------------	--	-----------	----	--	--	--	------	----------	---	----	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST357	152	
-------	-----	--

114752	1	
--------	---	--

115371	150	
--------	-----	--

115422	1	
--------	---	--

ST358	16	
-------	----	--

113359	16	
--------	----	--

AN4-15A Bolt		Purchased	No				Each	577.0000	8	32			
---------------------	--	-----------	----	--	--	--	------	----------	---	----	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST338	112	
-------	-----	--

ST358	465	
-------	-----	--

107737	12	
--------	----	--

108868	60	
--------	----	--

109148	4	
--------	---	--

111295	52	
--------	----	--

112905	12	
--------	----	--

114232	3	
--------	---	--

114292	32	
--------	----	--

114615	56	
--------	----	--

114784	58	
--------	----	--

115108	76	
--------	----	--

115371	100	
--------	-----	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 3:20:40 PM

Page 2

Work Order ID: 62585

Parent Item: D206-628-021BL

Parent Item Name: Heli-Access-Step LH, Blue

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

AN960JD416 NAS1149D0463J Purchased No

Each 24.0000 12 48



Washer



M15047 10/10/10

Location

Loc Qty

Loc Code

ST300

24

113288

24

D2724-041 Manufactured No

Each 0.0000 1 4



206L Step Assembly



2x B62587 10/10/10

D2731-7 Manufactured No

Each 55.0000 4 16



Mounting Lug



*10/10/10
B62580 4x 10/10/10*

Location

Loc Qty

Loc Code

ST420

16

60996

16

ST470

39

59202

15

61653

24

D2732-030 Manufactured No

Each 0.0000 8 32



Rubber Cushion



*8 feet
B56516 10/10/10*

D3394-043 Manufactured No

Each 31.0000 4 16



Lug Assembly



*10/10/10
B62589 10/10/10*

Location

Loc Qty

Loc Code

ST420

19

60997

19

ST475

12

52331

12

Monday, October 04, 2010 3:20:40 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 3:20:40 PM

Page 3

Work Order ID: 62585



Parent Item: D206-628-021BL



Parent Item Name: Heli-Access-Step LH, Blue

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

Each

4,434.000

12

48



Nut



10/10/19 sf (48)

Location

Loc Qty

Loc Code

ST300

4434

113422

68

114523

8

114718

16

114784

32

115108

1310

115589

1900

115621

1100

4e

Monday, October 04, 2010 3:20:40 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

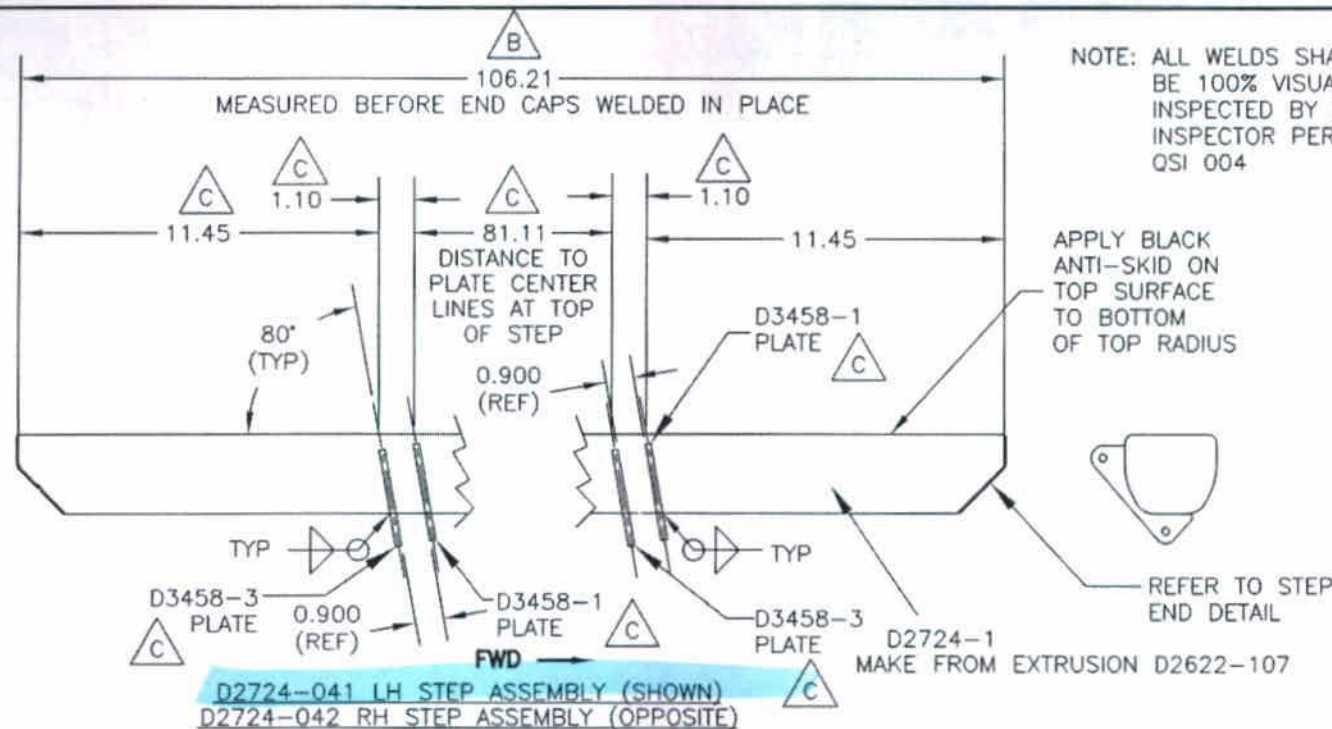
5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	AN960JD416	WASHER
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

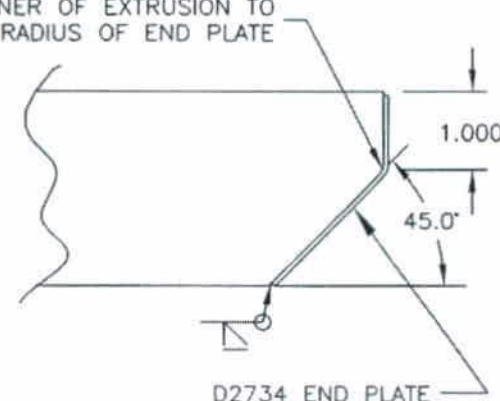
REFERENCE ONLY
DART

RELEASED
05.11.14



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X	X	D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19			
	A	97.12.04		NEW ISSUE
	B	98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES
	C	05.09.19		RE-DESIGN, ADD D3458-1/-3
TITLE				206L/407 STEP ASSEMBLY
				SCALE
				NTS
				SHEET 1 OF 1
				REV. C

Change Record

Part Number D206-628-021/-022
Description HELL ACCESS-STEP installation (206L)

Page 1 of 1[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries